

Date: Monday, 2/11/2008 2:12:22 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	CHAFING SHIELD
Job Number	37343			
Estimate Number	11138			
P.O. Number			Part Number	D31901
This Issue	2/11/2008	S.O. No. :	Drawing Number	D3190 REV A
Prsht Rev.	NC		Project Number	N/A
First Issue	/ /	Type : MACHINED PARTS	Drawing Revision	A
Previous Run	33427		Material	
Written By			Due Date	2/18/2008
Checked & Approved By	2/08/02/11		Qty:	10
Comment	Um: Each Est. A 03.05.26 New issue KJ/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S25GA 268A	304/316 .020" Sheet
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Comment: Qty.: 0.2261 sf(s)/Unit Total : 2.2607 sf(s)

304/316 SS .020" Sheet

Material: AISI 304/316 SS 0.020" thick sheet
(M304S25GA)

Batch: M105591

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut blank: 9.25" x 3.13"

Grind corner as per Dwg D3190

Deburr

Roll as per Dwg D3190

mf 08-02-21 (10)
 08/02/19 (10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB 08/02/22 (10)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 1A

CS/22 (10)

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

2008/2/22 (10)

Job Completion



2008/2/22 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/01/20
 QA: N/C Closed: _____ Date: _____

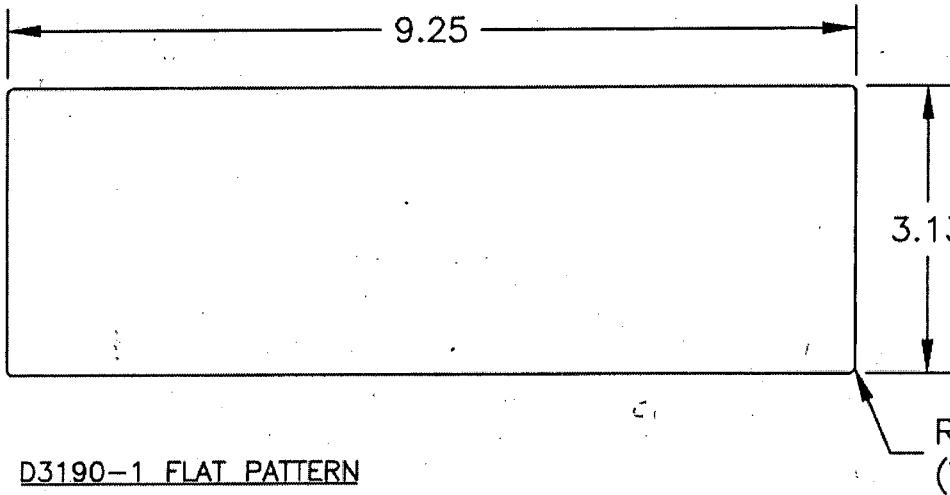
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

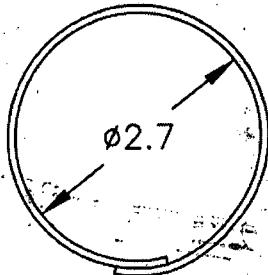
DART

COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A D3190 SHEET 1 OF 1
DATE	03.05.16	TITLE	SCALE CHAFING SHIELD 1:2
A	03.05.16	NEW ISSUE	

RELEASED
03.05.22

D3190-1 FLAT PATTERN



SHOP COPY
RETURN TO
D3190-1 ROLLING DETAIL
NOT TO SCALE ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37343

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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